

**\*82064\***

Thursday, March 22, 2012 1:15:01 PM

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

$\begin{matrix} *16* \\ *16* \end{matrix}$

**Cust Item ID:**

**Customer:**

Run Start \*NR1\*

Date:

Date:

Stop **\*NR2\***

<b>Draw Nbr</b>	<b>Revision Nbr</b>
D3535	Rev B

0.00

**\*100\***

## FLOW WATER JET

## Waterjet

## Memo

FLOW CNC Waterjet

1-Cut as per Dwg D3535    Dwg Rev:   D      Prog Rev:   D      2-  
Deburr if necessary

304 - 040

110

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*110\***

QC

## Memo

0.00

## Quality Control

120

QC8- Inspect parts - second check

0.00

**\*120\***

QC

## Memo

0.008124/09

## Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 82064

\*82064\*

Page 2

Thursday, March 22, 2012 1:15:01 PM

Item ID: D3535-35 Accept \*N900040100\* Setup Start \*NS1\*  
Revision ID: Stop \*NS2\*  
Item Name: Wearshoe  
Start Date: 3/22/2012 Start Qty: 16.00 \*16\* Cust Item ID:  
Required Date: 3/29/2012 Req'd Qty: 16.00 \*16\* Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130	NC BRAKE	0.00				(14)			
*130*									
Brake NC	Memo	0.00							
Brake NC	1-Deburr if necessary 2-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326.3-Identify as D3535-35.								

SB 12/04/09

140	QC5- Inspect part completeness to step on W/O	0.00							
*140*									
QC	Memo	0.00				(46)			
Quality Control									

Sticker

150	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
*150*									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 11:45 OVEN TEMPERATURE: 1275								

16X ✓

mk 12/04/10

M 117338

11:45  
3200 F  
1275

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 82064

Thursday, March 22, 2012 1:15:01 PM

**\*82064\***

Page 3

Item ID: D3535-35 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Wearshoe  
Start Date: 3/22/2012 Start Qty: 16.00 **\*16\*** Cust Item ID:  
Required Date: 3/29/2012 Req'd Qty: 16.00 **\*16\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
<b>*160*</b>						16	Ø		12/12/10
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <u>F-P1</u>	0.00							
<b>*170*</b>						16x	Ø		M-L 12/04/10
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
<b>*180*</b>									12/14/12
QC	Memo	0.00							
Quality Control									

12-04-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Thursday, March 22, 2012 1:15:05 PM

Page 1

Work Order ID: 82064

\*82064\*

Parent Item: D3535-35

\*D3535-35\*

Parent Item Name: Wearshoe

Start Date: 3/22/2012

Required Date: 3/29/2012

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP Rev:A New Issue 07-02-15 JLM  
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	- sf	161.1609	0.8022	13.51074	(14)		

\*M304S20GA\*

\*\*

304/316 .040 Sheet

Location	Loc Qty	Loc Code
MAT020	161.160922	
116623	0.2	
117933	27.3442	
118400	21.1723	
118964	36.5	
119346	29.8	
120604	46.144422	

121192.

121192.

*Handwritten signature*

120405

(16)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



DART AEROSPACE LTD		Work Order:	82064
Description: Wearshoe		Part Number:	D3535-35
Inspection Dwg: D3535 Rev: B		Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.000	+/-0.010	2.001	✓		Vern	HB-02
1.885	+/-0.010	1.887	✓		Vern	HB-02
6.00	+/-0.030	6.006	✓		vern	HB-02
6.75	+/-0.030	6.756	✓		vern	HB-02
Ø0.188	+0.005/-0.001	0.189	✓		vern	HB-02
23.250	+/-0.010	23.250	✓		MT	HB-01
19.750	+/-0.010	19.750	✓		MT	HB-01
17.750	+/-0.010	17.750	✓		MT	HB-01
14.250	+/-0.010	14.250	✓		MT	HB-01
9.500	+/-0.010	9.508	✓		Vern	Prod-w-S-02
4.750	+/-0.010	4.754	✓		Vern	HB-02
0.300	+/-0.010	0.300	✓		Vern	HB-02
0.300	+/-0.010	0.300	✓		Vern	HB-02
0.038	+/-0.010	0.035	✓		vern	HB-02

Measured by:	Jm
Date:	12/04/05

Audited by:	S
Date:	12/04/05

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM	E

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

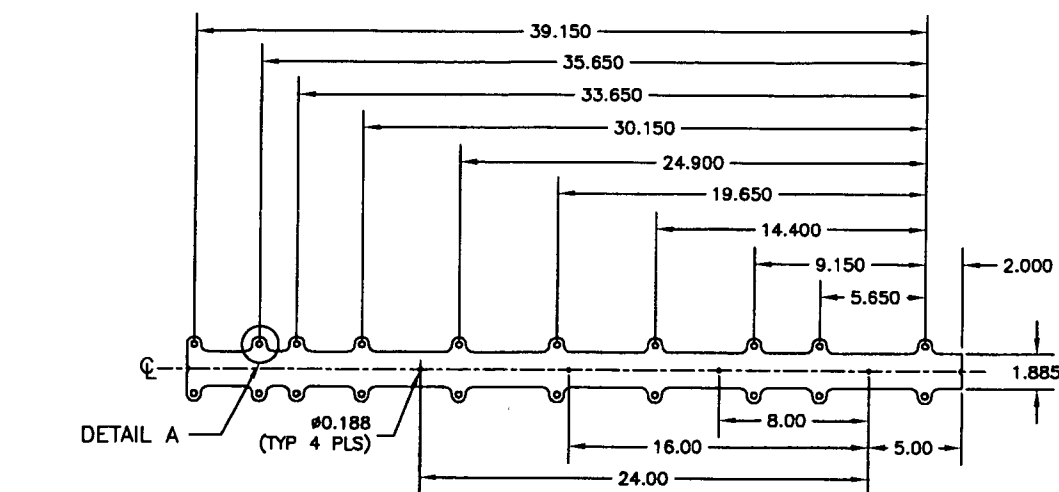
**NOTE:** Date & initial all entries

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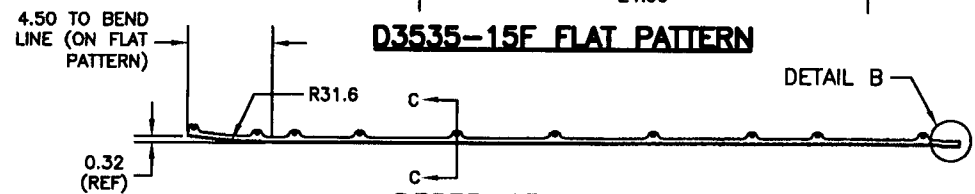
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07.04.24

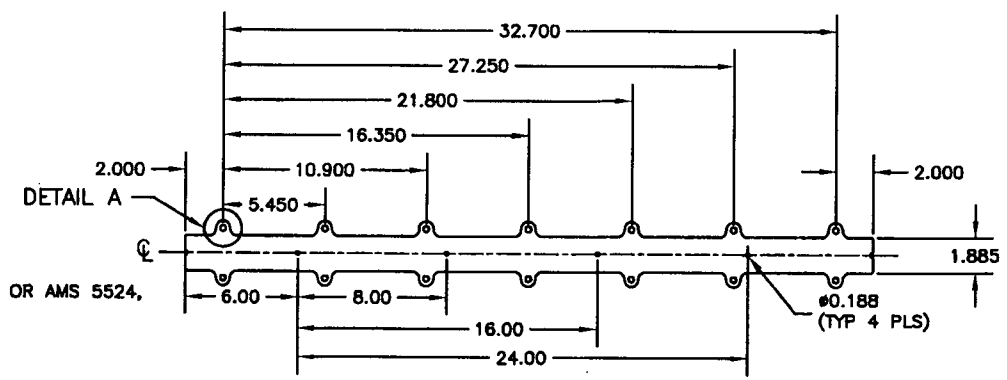
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	PORT HADLOCK, WA
DATE 07.04.17	TITLE WEARSHOE	DRAWING NO. <b>D3535</b>
		REVISION <b>REV. B</b>
		SHEET 2 OF 7
		SCALE 1:10



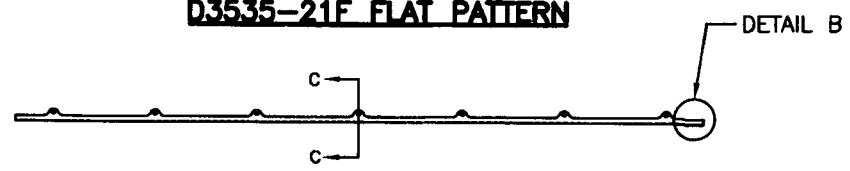
**D3535-15F FLAT PATTERN**



**D3535-15 BEND DETAIL**



**D3535-21F FLAT PATTERN**



**D3535-21 BEND DETAIL**

**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT CL
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

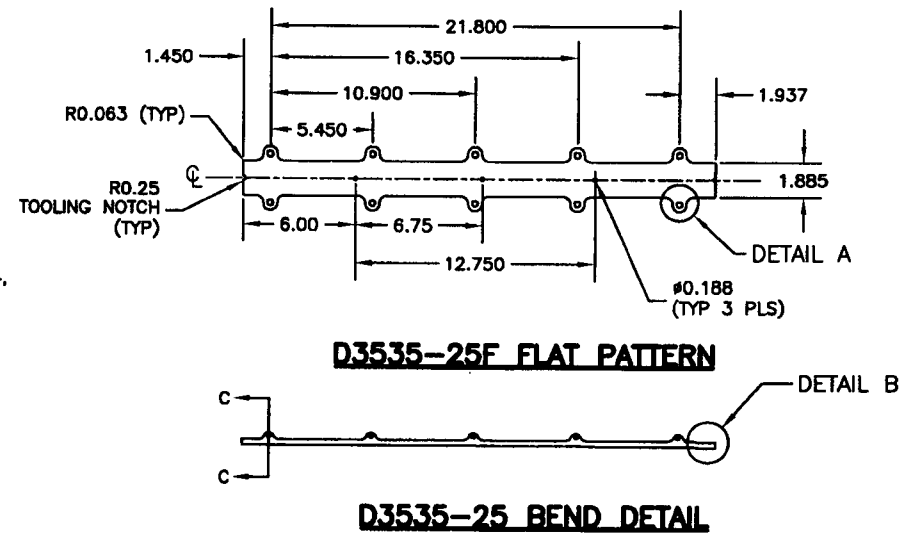
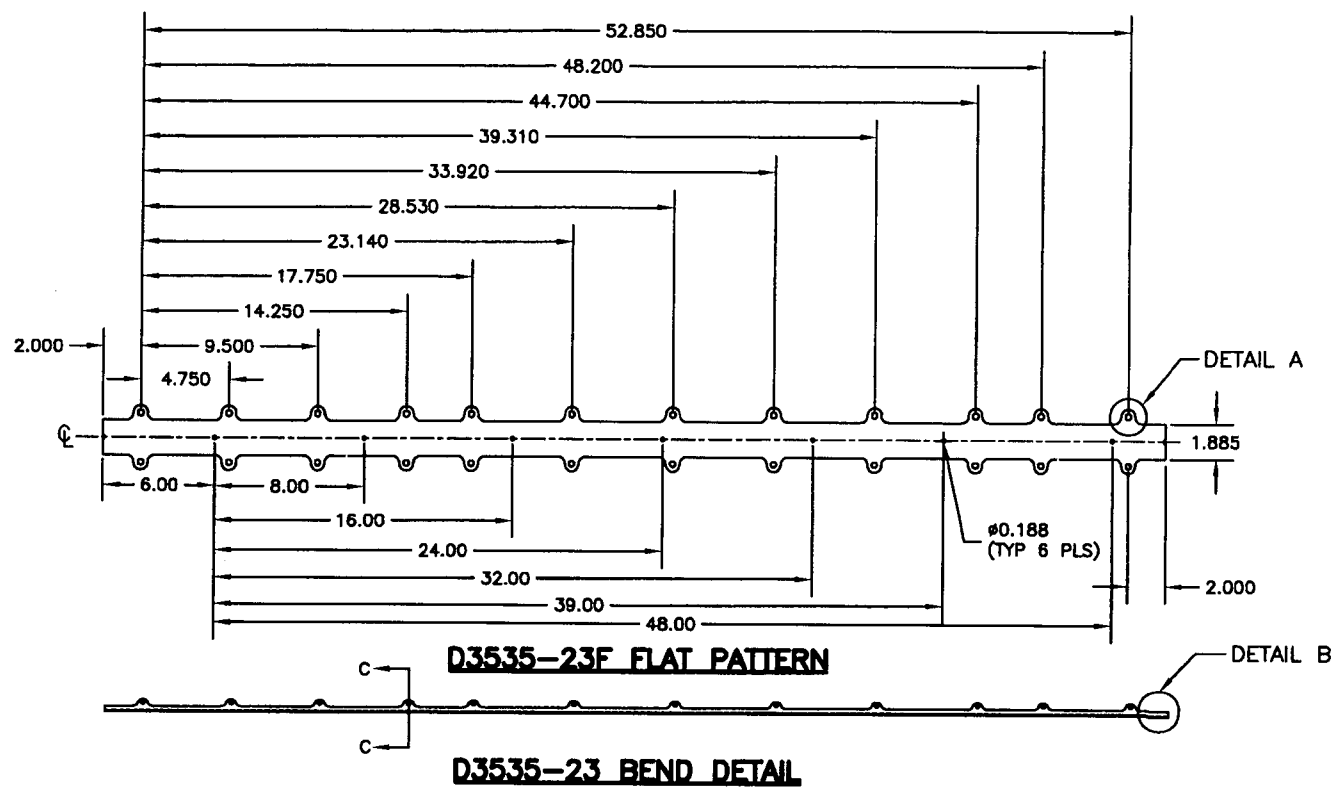
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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07.04.24



- NOTES**
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
  - 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
  - 3) PART IS SYMMETRICAL ABOUT C
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 5) ALL DIMENSIONS ARE IN INCHES
  - 6) BREAK ALL SHARP EDGES TO 0.010 MAX
  - 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
  - 8) SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN	CB	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	07.04.17	TITLE	D3535	WEARSHOE
				SCALE 1:10
				SHEET 3 OF 7
				REV. B

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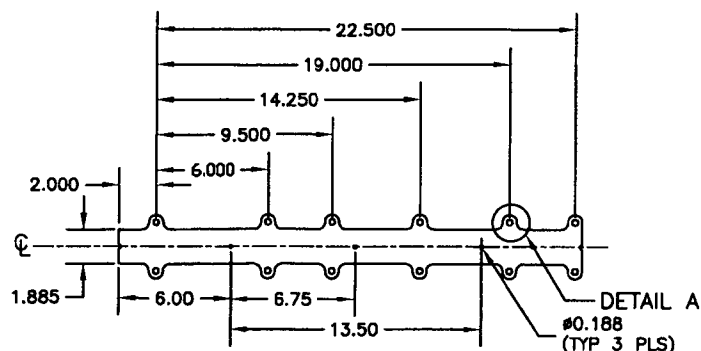
**NOTE:** Date & initial all entries



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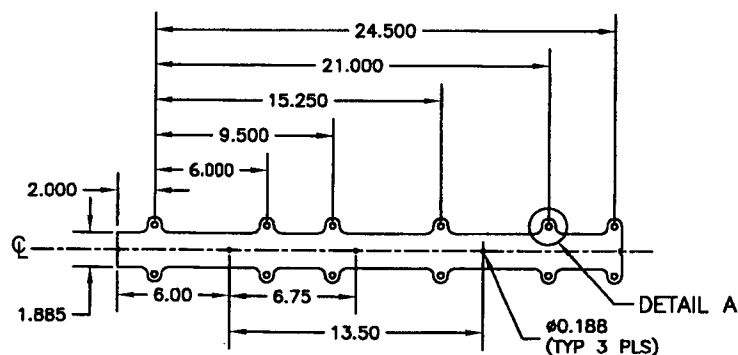
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**D3535-31F FLAT PATTERN**



**D3535-31 BEND DETAIL**



**D3535-33F FLAT PATTERN**



**D3535-33 BEND DETAIL**

**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)  
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER QSI 005 4.3
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DESIGN <b>CB</b>	DRAWN BY <b>PH</b>	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3535</b>	REV. B
DATE <b>07.04.17</b>	TITLE <b>WEARSHOE</b>	SHEET 4 OF 7	SCALE <b>1:10</b>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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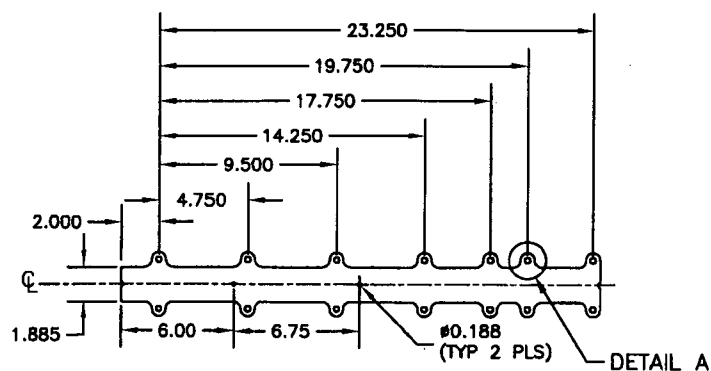
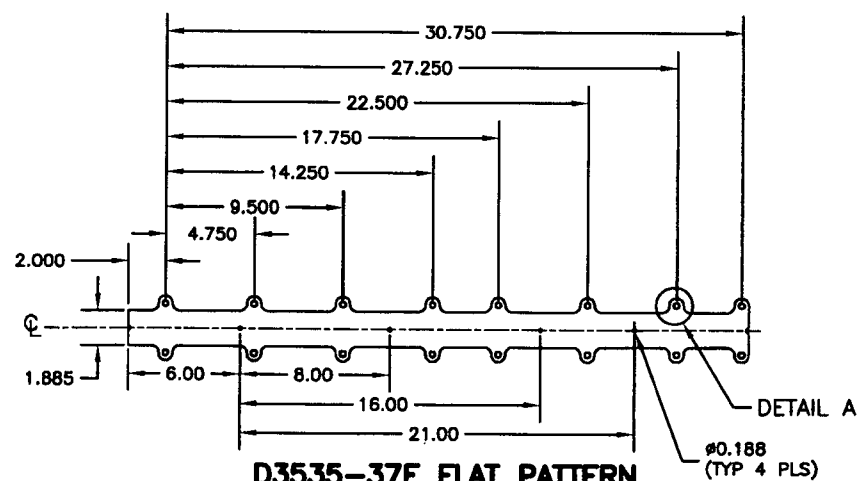
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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 5 OF 7
		SCALE	1:10	

**D3535-35F FLAT PATTERN****D3535-35 BEND DETAIL****D3535-37F FLAT PATTERN****D3535-37 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)  
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
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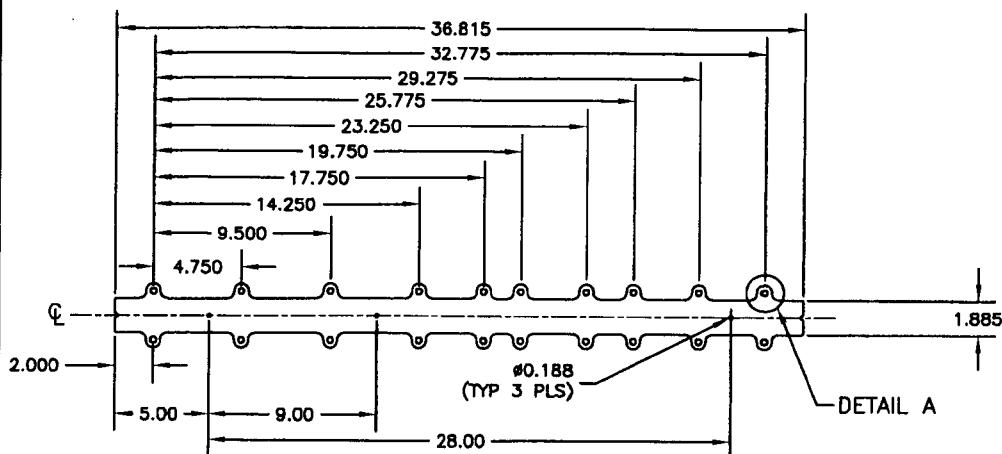
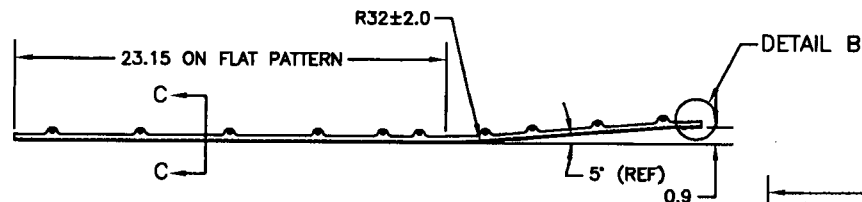
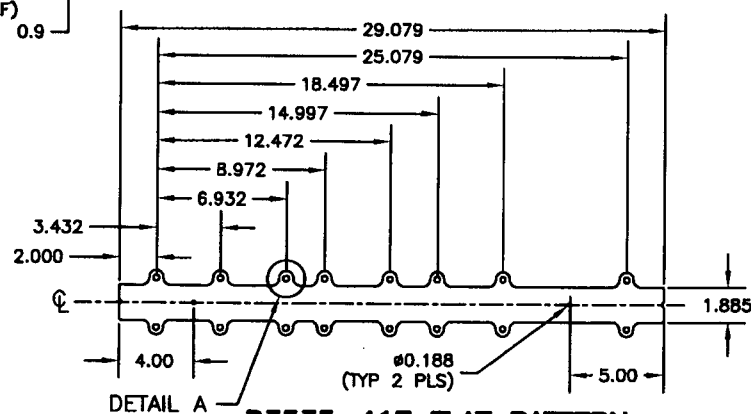
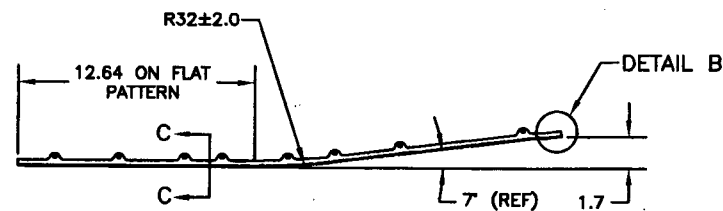
**NOTE:** Date & initial all entries

82067

**DART**

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07.04.17

**D3535-39F FLAT PATTERN****D3535-39 BEND DETAIL****D3535-41F FLAT PATTERN****D3535-41 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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DESIGN	C.B.	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	07.04.17	DRAWING NO.	D3535	REV. B
TITLE	WEARSHOE	SHEET	6 OF 7	SCALE
				1:10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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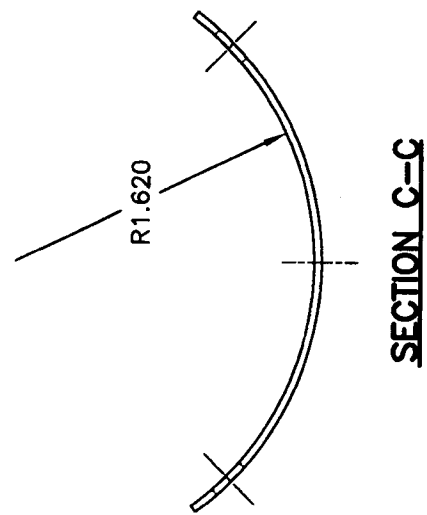
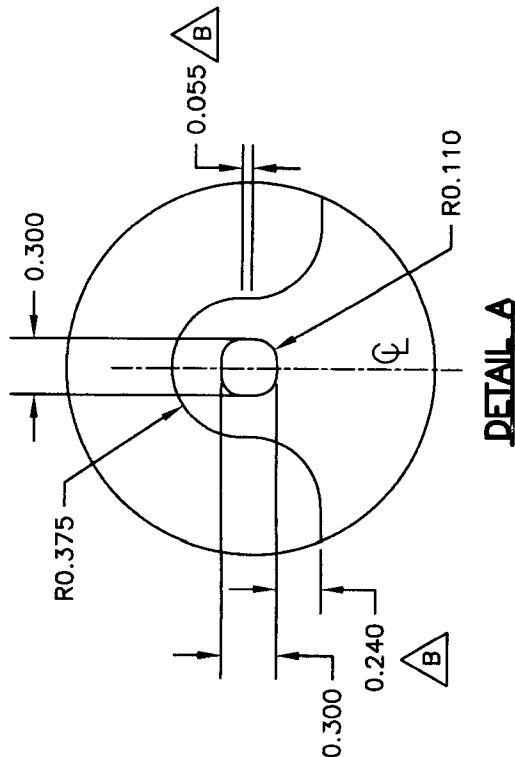
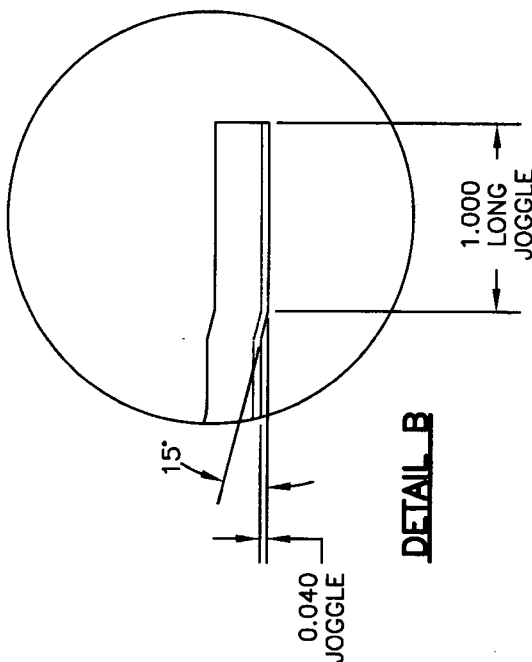
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DESIGN <b>CB</b>	DRAWN BY <b>PH</b>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 	APPROVED 	DRAWING NO. D3535	REV. B SHEET 7 OF 7
DATE 07.04.17	TITLE WEARSHOE		SCALE 1:1

RELEASED

07.04.24



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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries